

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000349**Date Inspected:** 10-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA

CWI Name:	Jesse Cayabyab		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Procedure Qualification Plate (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Flour (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Companys Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Jesse Cayabyab, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed welding being performed on a non-PQR test plate that was tacked in the 1G position onto the same fixture as the actual PQR test plate known as ABF-PQR-025-1A (high heat). This will be the second attempt to weld this PQR plate. Mr. Cayabyab checked welding amperage, voltage and travel speed parameters while the depositing weld metal onto the non-PQR test plate. The QC Inspector and the welding operators agreed that welding parameters were capable of producing sound weld. The non-PQR test plate was removed and the QA Inspector observed the root pass being deposited on PQR test plate using .072 inch diameter (1.8mm) Hobart Fabshield XLR-8 flux-cored arc welding (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. Welder Dan Gordon deposited (6) further weld passes. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated on this date.

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Summary of Conversations:

The QC Inspector informed the QA Inspector the final passes on this PQR plate would begin the start of shift on the following Monday.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
